

5/15


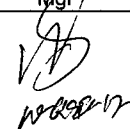

DART AEROSPACE LTD	Work Order:	22648
Description: Fitting	Part Number:	D3299-1
Dwg: D3299 Rev. A1 <i>of 11.16</i>	Qty:	6 5
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	<i>JA</i>	05.03.09	5
2	MC	Cut blank: 2.200" long Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 1.625" Hex (M6061T6H1.625) Identify as D3299-1 Batch: <u>M15717</u>	SA	05.03.29	10 7 <i>T10</i>
3	MC	Turn as per Folio FA451 and Dwg D3299	SA	05.03.29	10 7
4	QC2	Inspect parts as they come off the CNC machine	SA	05.03.29	10 7 <i>✓ AB</i>
5	MV	Machine as per Folio FA451 and Dwg D3299	JL	05/04/04	6 <i>PSO</i>
6	QC2	Inspect parts as they come off the CNC machine	<i>R</i> /JL	05/04/04	6
7	QC8	Second check	<i>FM</i>	05/04/04	6
8	MV	Deburr	JL	05/04/04	6
9	PG	Issue P/O: <u>2008003</u> Anodize as per Dwg D3299 Possible Supplier: TNM Paint Material release note is required	<i>U</i>	05.04.04	6
10	RG	Receive and Inspect for transit damage Ensure material release note is attached	CL	05/05/12	6
11	QC5	Inspect work to Step 10	<i>J</i>	05.05.12	6
12	ST	Identify and Stock <i>IDENTIFY with Dart Part #; Batch # 0507 AFINE Paint Requirement</i>	CL	05/05/12	6
13	AC	Cost / part: <u>68.01</u>	<i>AL</i>	05/05/13	6
14	DC	Close W/O <u>63.49</u> Inspect Level 21	<i>JA</i>	05.05.26	6

Rev	Date	Change	Revised By	Approved
A	04.10.04	New issue	KJ/JLM	<i>[Signature]</i>

RELEASED
[Signature] 04-10-04

8455

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
05.03.29	2	Dwg. needs to be updated with 1.625 hex stock, curatly drawn with 1.5 stock		05.05.24	N/A	 05.05.24	 05.05.24	

NCR: 22648		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
050330	3	3 SCRAP Taper prog. did not match thread	<i>[Signature]</i> 050330	destroy	SD 05.03.29	<i>[Signature]</i> 0503.30	<i>[Signature]</i> 0503.30	<i>[Signature]</i> 0503.30
05/04/04	5	1 scrap chamfer .688 too big .".740" operator error	<i>[Signature]</i> 050404	destroy & replace	J.L 05/04/04	<i>[Signature]</i> 05-04-04	<i>[Signature]</i> 050404	<i>[Signature]</i> 050404

Part No: D3299-1 PAR #: _____ Fault Category: Prod/machined parts NCR: Yes No DQA: 1 Date: 05/05/26
 NOTE: Date & initial all entries QA: N/C Closed: 1 Date: 05.05.26

DART AEROSPACE LTD		Work Order: 22648
Description: Fitting		Part Number: D3299-1
Inspection Dwg: D3299	Rev: A1 <i>04.11.16</i>	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

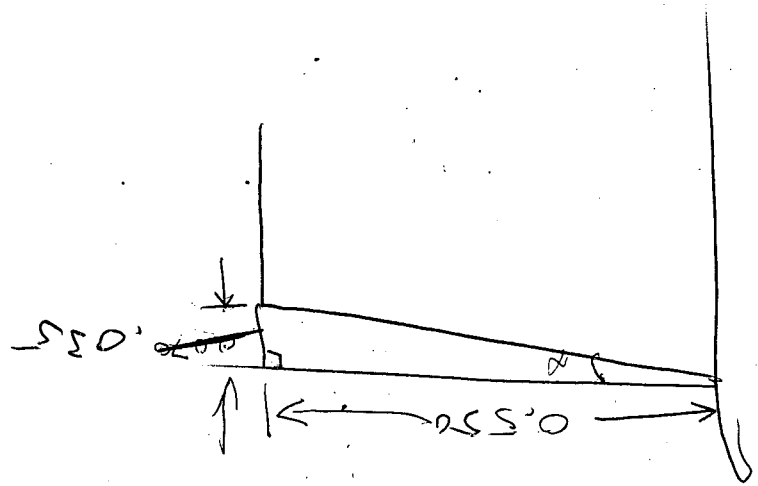
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25	+/-0.030	1.252	✓		Vern	
0.476	+0.000/-0.005	.474	✓			
0.550	+/-0.010	.555	✓			
1.00	+/-0.030	1.003	✓			
2.10	+/-0.030	2.111	✓			
0.773	+/-0.010	.777	✓		Vern	
0.10	+/-0.030	.100	✓			
0.20	+/-0.030	.190	✓			
0.550	+/-0.010	.550	✓			
MOW Max = 0.573 Min = 0.565	Max = 0.573	.5695	✓			
Ø0.302	+0.005/-0.000	Ø.307	✓			
Ø0.688	+0.005/-0.000	.685	✓		Vern	
Ø0.580	+0.005/-0.000	.581	✓		Vern	
53°	+/-0.5°					

Measured by: SD/J.L	Audited by: ml	Prototype Approval:	N/A
Date: 05/03/29 05/04/04	Date: 05/04/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.11.12	New Issue	KJ/JLM	<i>[Signature]</i>

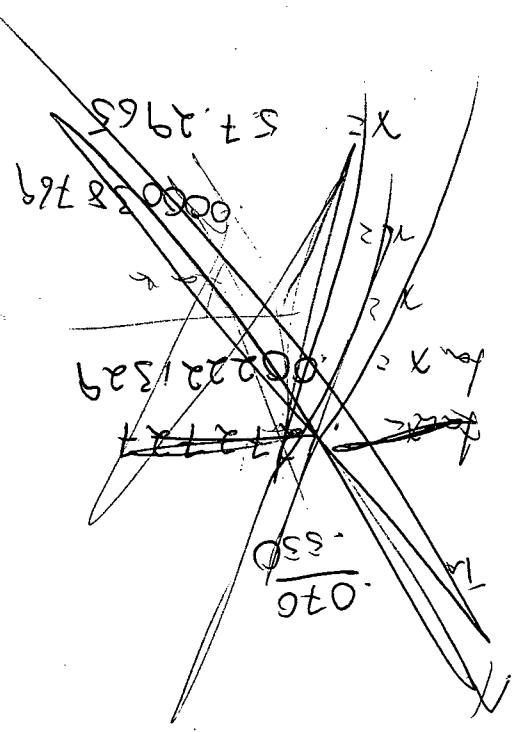
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[Signature] 04.11.15

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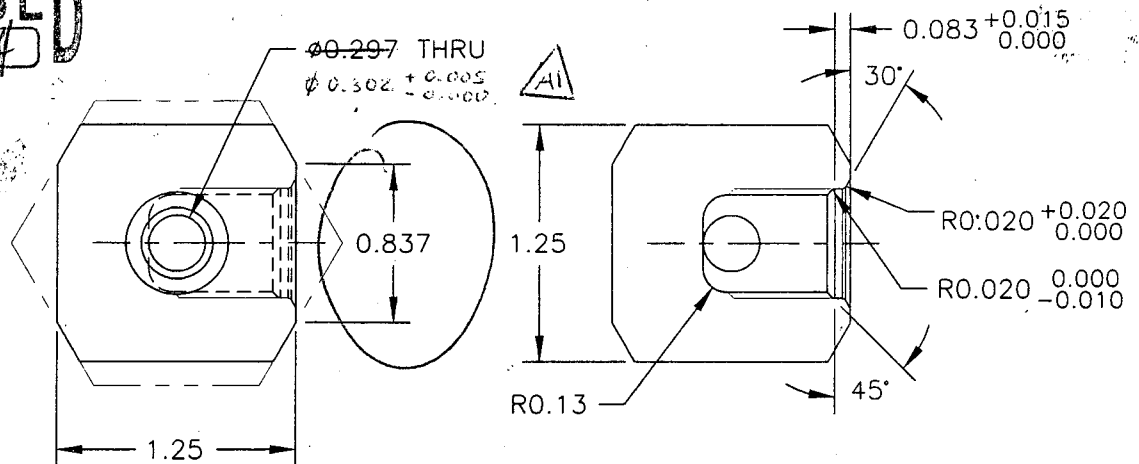
Vol



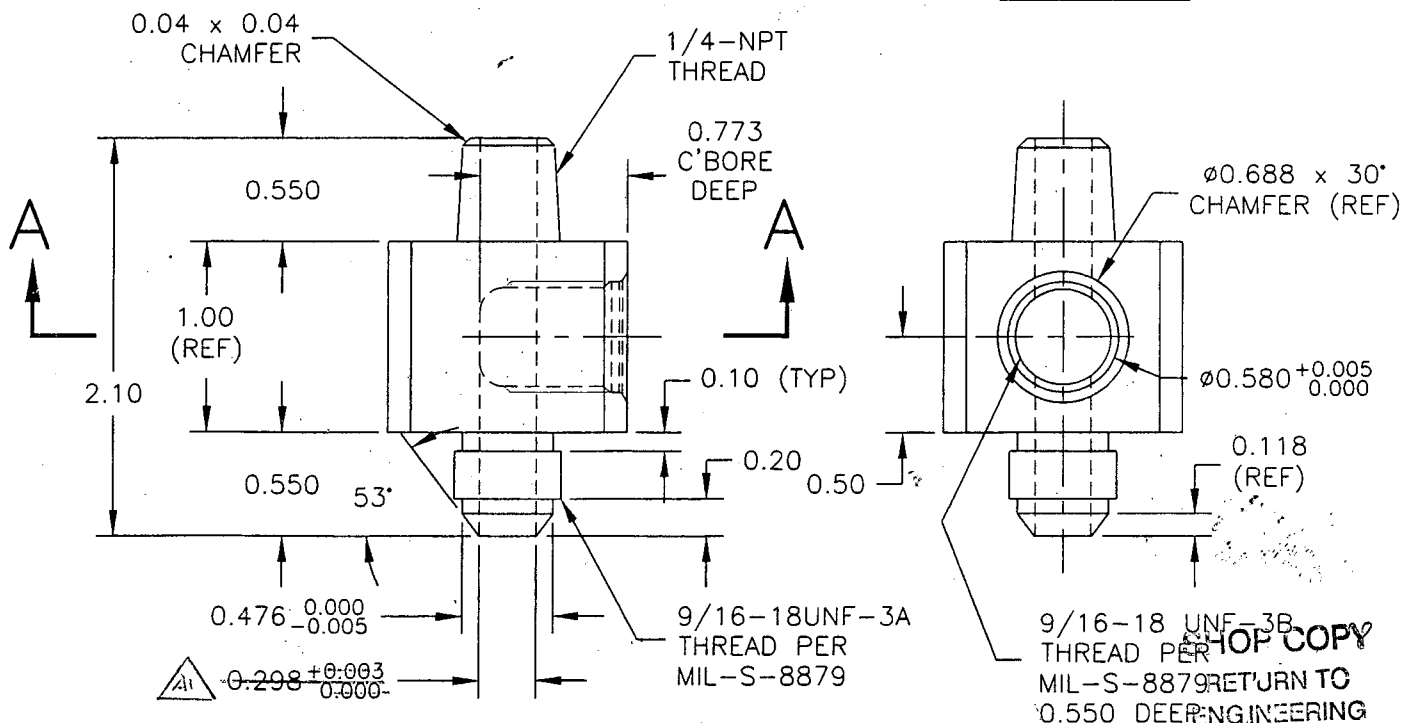


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3299	REV. A SHEET 1 OF 3
DATE 04.07.06		TITLE FITTING	SCALE 1:1
A	04.07.06	NEW ISSUE	
AI	<i>[Signature]</i> 04.11.15	$\phi 0.302$ WAS $\phi 0.297$; ADD $\phi 0.540$ & R0.13	

RELEASED
04.09.09 *[Signature]*



SECTION A-A



D3299-1

D3299-1 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625) ENDMENT
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR, IB OR IC OR II OR IIB, CLASS II NOTICE
POSSIBLE SUPPLIER: ANODIZING TMM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

UNCONTROLLED COPY

WORK ORDER
NO. 22648

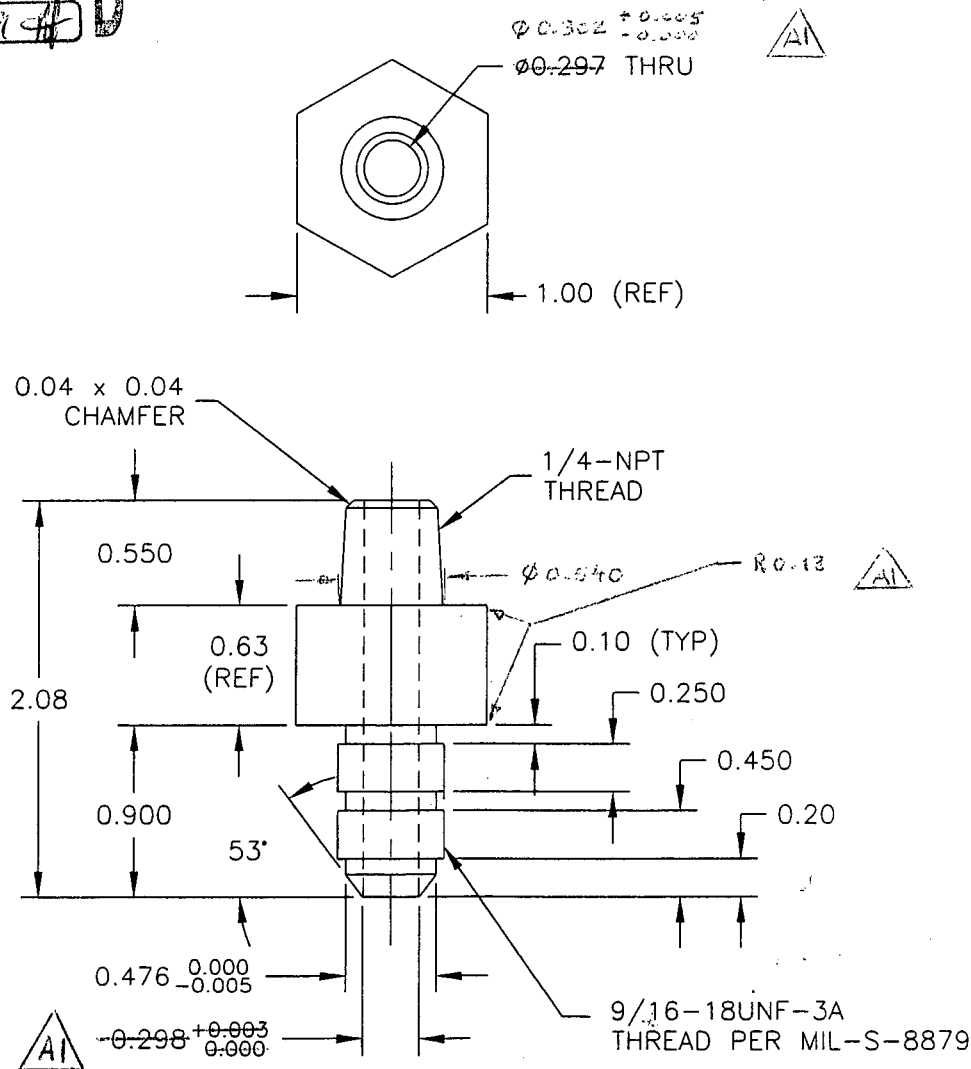
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DESIGN <i>RT</i>	DRAWN BY <i>RT</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. D3299	REV. A SHEET 2 OF 3
DATE 04.07.06		TITLE FITTING	SCALE 1:1

RELEASED
04.09.06 *CH*



D3299-3

SHOP COPY
RETURN TO
ENGINEERING

D3299-3 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.00 HEX BAR (M6061T6H1.000)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB-CLASS-2/AMENDMENT
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

WORK ORDER
NO. 22648

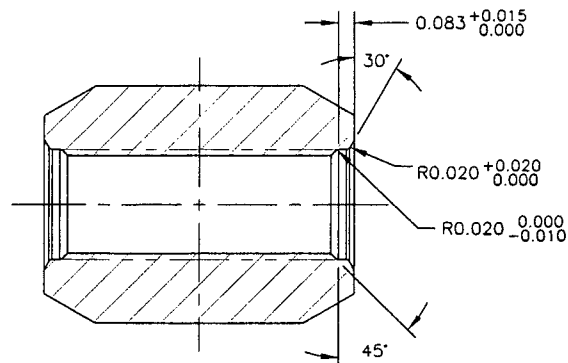
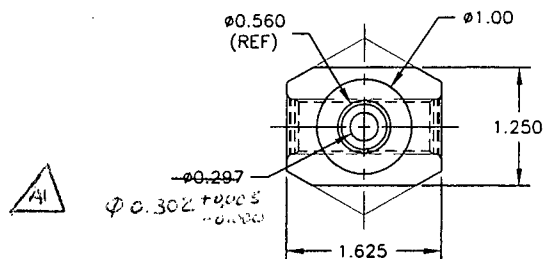
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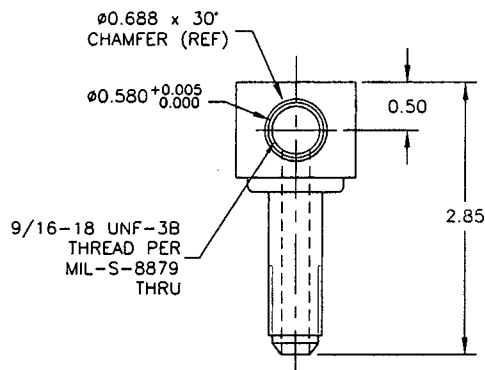
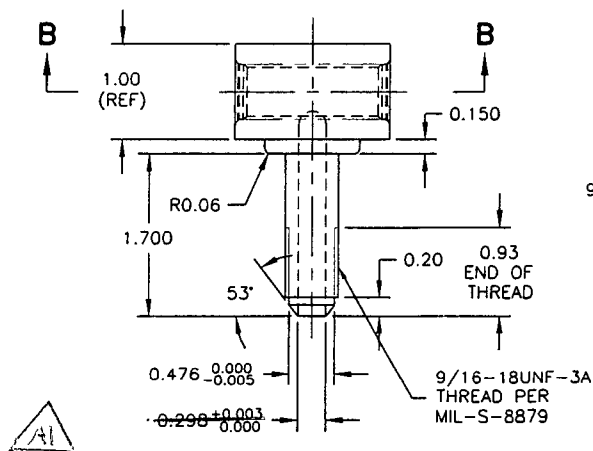


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3299	REV. A SHEET 3 OF 3
DATE 04.07.06		TITLE FITTING	SCALE 1:2

RELEASED
04.07.06



SECTION B-B
SCALE 1:1



D3299-5

SHOP COPY
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ENGINEERING

D3299-5 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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SLIP
REVISION
NOTICE

WORK ORDER

NO. _____

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Mar 08, 2005
03:17 pm

Work Order No	: 0022648	Department Code:	
Project Name	: D3299-1	Burden Flags	: NNNNNNN
Project For	: WK515	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D3299-1	Invoice Number	:
Description	: Fitting	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 5	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 03-08-05		
Est Finish Date	: 04-10-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:		

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

84422 1M
84422 101
58622 6104pt

2.1
1.203

TNM**ANODISATION et PEINTURE TNM INC.**

C. OF C

4454 Garand, Ville St. Laurent, QC H4R 2A2
Telephone: (514) 335-7001 Fax: (514) 335-3920
Certifié ISO 9001-2000 / ISO 9001-2000 certified
Certifié NADCAP / NADCAP certified

40916

06-May-2005

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

**CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE****PURCHASE ORDER/
NO. DE COMMANDE: 2008003**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	6	6	D3299-1 FITTING	B23012 BLUE ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER
2	13	13	D3299-3 FITTING	B22648 BLUE ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER

Nous certifions que les articles énumérés ont été procédés accordément à l'inspection ci-haut.
Les cartes de travail ont été remplies et sont disponibles pour consultation sur demande.

We hereby certify that the above parts have been processed in accordance with the above inspection.
Travel cards have been filed and are available for viewing upon request.

Signature/Signed: _____

☐ Directeur de la Qualité / Q.A. Manager ☐